

4-2/23



Dart Aerospace Ltd.
1270 Aberdeen St
Hawkesbury, ON
K6A 1K7
Canada

Tel (613) 632-5200

D350-591-312
Job Sheet 175293



Part No: D350-591-312

Job Qty: 3 ea

Part Name: Heli-Access-Step™ RH - High Gear, Long Step, Aerazur Float Compatible



Part Weight: 0 lbs

Status: Scheduled

Priority: Medium

Job Created: 4/2/18

Job Tracking No:

Due Date: 4/2/18

Created By: Michelle Gagnon-Donovan

Type: SOLD

Description:

Note: DWG REV B IPP Rev:A 04.03.22 New issue KJ/RF IPP Rev:B 07-06-09 Added D3572-1 JLM IPP Rev:C 08-04-02 ECN1163 DD verified by:EC IPP Rev:D 08-04-08 ECN1164 DD verified by:eC IPP Rev:D fixe route seq in born DD 10.04.28 verified by:EC

Ship Via:

was w/o #172736 - Part number discrepancy new w/o created m...

Bill of Materials

Job Routing

Op No	Operation	Qty	Start Date	Due Date	Standard		Workcenter/Supplier		Sign-off
					Setup hrs	Run Hrs	Workcenter / Supplier	Lead Time	
90	Start up Operation	3 Ea		3/31/18	0.00	0.00	Start Up Large Fab-4		
180	Large Fab	3 pcs		3/31/18	0.00	3.00	Large Fab 2		
190	QC	3 pcs		3/31/18	0.00	0.00	QC10		
200	QC	3 pcs		3/31/18	0.00	0.00	QC5		
210	HandFinish	3 pcs		3/31/18	0.00	0.56	HandFinish1		
220	Powdercoat	3 pcs		3/31/18	0.00	0.89	Powdercoat1		
230	HandFinish	3 pcs		4/2/18	0.00	0.56	HandFinish3		
240	QC	3 pcs		4/2/18	0.00	0.00	QC3		
250	Packaging	3 pcs		4/2/18	0.00	0.00	Packaging1-3		
260	QC	3 pcs		4/2/18	0.00	0.00	QC4		
265	DC	3 pcs		4/2/18	0.00	0.00	DC		
270	Packaging	3 pcs		4/2/18	0.00	0.00	Packaging3-1		
280	QC21-FG	3 Ea		4/2/18	0.00	0.00	QC21		

Part Op 180 - 1-Assemble Leg Assembly as per Dwg D3272. 2-Leave one rivet out until welding is complete. 3-Bevel Aft end for Descriptions: welding 4-Inspect for foreign object as per QSI 024 5-Weld Aft End Plate as per QSI 004 & Dwg D3272 A/R Aluminum Rod M138760 6-Grind End Plate flush 7-Install last rivet as per Dwg.

220 - START TIME: 2:55 OVEN TEMPERATURE: 800 FINISH TIME: 3:25

265 - Photocopy bluefile and type labels as per PPP D350-591-312 CHG001

270 - Identify and pack for shipping as per PPPD350-591-312 Location :FG072



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Container No: S057645



Part: D350-591-312

Job No: 175293

Serial No/Batch: S057645

Revision:

Inspector:

Date: 04/03/18

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Job BOM

Part / Item	Component Name	Quantity	Operation	Container
D350-591-312	Heli-Access-Step™ RH - High Gear, Long Step, Aerazur Float Compatible	3 Ea (1 ea)	90-Start up Operation	S057388 S057639
D3065-041	Step Leg Assembly	3 Ea (1 ea)	180-Large Fab	S057646
D3066-1	Spacer	6 Ea (2 ea)	180-Large Fab	S057647
MS20600-AD4W4	Rivet	48 Ea (16 ea)	180-Large Fab	S041171
AN3-35A	Bolt	6 Ea (2 ea)	250-Packaging	
AN4-13A	Bolt	24 Ea (8 ea)	250-Packaging	
AN5-36A	Bolt	6 Ea (2 ea)	250-Packaging	
D2230-3	Mounting Lug	12 Ea (4 ea)	250-Packaging	
D2618	Bushing	6 Ea (2 ea)	250-Packaging	
D2856-400	Abrasion Strip 4" Wide (Per Foot)	3.6000 Ea (1.2 ea)	250-Packaging	
D3235-1	Mounting Lug	6 Ea (2 ea)	250-Packaging	
D3278-041	Support Assembly	3 Ea (1 ea)	250-Packaging	
MS21042L3	Nut	6 Ea (2 ea)	250-Packaging	
MS21042L4	Nut	24 Ea (8 ea)	250-Packaging	
MS21042L5	Nut	6 Ea (2 ea)	250-Packaging	
NAS1149D0363J	Washer	12 Ea (4 ea)	250-Packaging	
NAS1149D0463J	Washer	48 Ea (16 ea)	250-Packaging	
NAS1149D0563J	Washer	12 Ea (4 ea)	250-Packaging	

Job Allocations

Operation	Component Part	Required	Inventory	Allocated
90-Start up Operation	D350-591-312	3	14	0
180-Large Fab	D3065-041	3	11	0
	D3066-1	6	72	0
	MS20600-AD4W4	48	1,071	0
250-Packaging	AN3-35A	6	238	0
	AN4-13A	24	907	0
	AN5-36A	6	212	0
	D2230-3	12	154	0
	D2618	6	402	0
	D2856-400	4	48	0
	D3235-1	6	232	0
	D3278-041	3	10	0
	MS21042L3	6	2,756	0
	MS21042L4	24	3,942	0
	MS21042L5	6	648	0
	NAS1149D0363J	12	2,980	0
	NAS1149D0463J	48	5,782	0
	NAS1149D0563J	12	1,962	0

Part Specifications

Specifications could not be found.

Plex 4/2/18 12:49 PM Dart.Gagnon.Michelle

002177



Dart Aerospace Ltd.
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Hawkesbury, ON
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Canada

Tel (613) 632-5200

D350-591-311
Job Sheet 172736



Part No: D350-591-311

Job Qty: 3 ea

Part Name: Heli-Access-Step™ LH - High Gear, Long Step, Aerazur Float Compatible



CHG 002

Part Weight: 0 lbs

Status: Scheduled

Priority: Medium

Job Created: 2/21/18

Job Tracking No:

Due Date: 3/8/18

Created By: Linda Lacelle

Type: Stock

Description:

Note: DWG REV B IPP Rev:A 04.03.22 New issue KJ/RF IPP Rev:B 07-06-09 Added D3272-1 JLM IPP C returned to CHG001 for Eurocopter, ref NCR08-082 LL verified by:EC IPP Rev:D fixe route seq in bom DD 10.04.28 verified by:EC

Ship Via:

Bill of Materials

Job Routing

Op No	Operation	Qty	Start Date	Due Date	Standard		Workcenter/Supplier		Sign-off
					Setup hrs	Run Hrs	Workcenter / Supplier	Lead Time	
90	Start up Operation	3 Ea	3/7/18	3/7/18	0.00	0.00	Start Up Large Fab-4		SLH
110	Large Fab	3 pcs	3/7/18	3/7/18	0.00	2.97	Large Fab 2		SLH
120	QC	3 pcs	3/7/18	3/7/18	0.00	0.00	QC9		PD 18-3-23
130	QC	3 pcs	3/7/18	3/7/18	0.00	0.00	QC5		PD 18-3-23
140	HandFinish	3 pcs	3/7/18	3/7/18	0.00	0.55	HandFinish1		SA 18-3-26
150	QC	3 pcs	3/7/18	3/7/18	0.00	0.00	QC7-2		PD 18-3-29
180	Large Fab	3 pcs	3/7/18	3/7/18	0.00	2.97	Large Fab 2		
190	QC	3 pcs	3/7/18	3/7/18	0.00	0.00	QC10		
200	QC	3 pcs	3/7/18	3/7/18	0.00	0.00	QC5		
210	HandFinish	3 pcs	3/7/18	3/7/18	0.00	0.55	HandFinish1		
220	Powdercoat	3 pcs	3/7/18	3/7/18	0.00	0.87	Powdercoat1		
230	HandFinish	3 pcs	3/8/18	3/8/18	0.00	0.55	HandFinish3		
240	QC	3 pcs	3/8/18	3/8/18	0.00	0.00	QC3		
250	Packaging	3 pcs	3/8/18	3/8/18	0.00	0.00	Packaging1-3		
260	QC	3 pcs	3/8/18	3/8/18	0.00	0.00	QC4		
265	DC	3 pcs	3/8/18	3/8/18	0.00	0.00	DC		
270	Packaging	3 pcs	3/8/18	3/8/18	0.00	0.00	Packaging3-1		
280	QC21-FG	3 Ea	3/8/18	3/8/18	0.00	0.00	QC21		

Part Op 110 - 1-Bevel end for welding FWD ONLY 2-Weld Support using Jig DT8719, weld Fwd End Plate as per QSI 004 & Dwg Descriptions: D3272 A/R Aluminum Rod M138673 3-Grind End Plate flush

180 - 1-Assemble Leg Assembly as per Dwg D3272. 2-Leave one rivet out until welding is complete. 3-Bevel Aft end for welding 4-Inspect for foreign object as per QSI 024 5-Weld Aft End Plate as per QSI 004 & Dwg D3272 A/R Aluminum Rod M138673 6-Grind End Plate flush 7-Install last rivet as per Dwg.

220 - START TIME: _____ OVEN TEMPERATURE: _____ FINISH TIME: _____

265 - Photocopy bluefile and type labels as per PPP D350-591-311 CHG001

270 - Identify and pack for shipping as per PPPD350-591-311 Location : FG084

DQA: _____ Date: _____

**WORK ORDER NON-CONFORMANCE / UPDATE**

QA Closed: _____ Date: _____

Work Order update only ☐

Work Order: _____ Part No. _____ NCR No. _____	DISPOSITION Rework ☐ Scrap ☐ Use-as-is ☐ Suspected Unapproved ☐	AGAINST DEPARTMENT/PROCESS Skid-tube ☐ Machining ☐ Thermoforming ☐ Large Fab ☐ Cross tube ☐ Small Fab ☐ Finishing ☐ Composite ☐ Water Jet ☐ Prod. Eng. Coord. ☐ Rec/Store/Packaging ☐ Supplier ☐ Engineering ☐ Quality ☐ Other ☐			
Date :	Step #:	QTY Effective :		MRB (QSI042) Approval	
Description Work Order Deviation		Disposition		Completed By	
				Lead hand / Supervisor Approval Verification	
				QC / QA Coordinator Approval	
Root Cause		FAULT CATEGORY			
Environment ☐	No Re-verification ☐	Pressure/Forced ☐	Temperature/Cure ☐	Power Loss/Surge ☐	Positioned Wrong ☐
Design ☐	Operator ☐	Bending ☐	Set-up ☐	Folio/Program ☐	Outside Dimensions ☐
Doc/Data ☐	Offset/Setup ☐	Centre Not Concentric ☐	BOM/Route ☐	Grain ☐	Over/Under tolerance ☐
Equip/Tooling ☐	Supplier ☐	Cracks ☐	Broken/Damage/Defect ☐	Weld ☐	Part Incorrect ☐
Handling/Pre ☐	Training ☐	Crimp/Kink/Ripple/Wave ☐	Inspection Incomplete/Unqualified ☐	Wrong Stock Pulled ☐	Part Lost/Missing ☐
Material ☐	Use for Testing ☐	Cuffs ☐	Contamination ☐	Out of Sequence ☐	Part Moved ☐
Internal Transport ☐	Poor Information ☐	Crushing ☐	Countersink ☐	Off-set ☐	Drawing ☐
Tribal Knowledge ☐	Rushing ☐	Heat Treat ☐	Cut Too Short ☐	Mislabeled ☐	Finish ☐
LOA ☐	Product Improvement ☐	Wave/Twist in Tube ☐	Instructions Incomplete/Unclear ☐	Fit/Function ☐	Misread ☐
Substation ☐	Process Improvement ☐	Marks/Chatter ☐	Drill Holes ☐	Misaligned/off center ☐	Turning Sequence ☐
Past Expiry Date ☐	Manufacturing Process ☐	OTHER : _____			
Misidentified ☐	Past Due ☐				

Job BOM

Part / Item	Component Name	Quantity	Operation	Container
D3067-1	End Plate	6 Ea (2 ea)	90-Start up Operation	S047606
D3219-1	Plate	6 Ea (2 ea)	90-Start up Operation	S047627
D3272-1	Step	3 Ea (1 ea)	90-Start up Operation	S05 1378
D3065-041	Step Leg Assembly	3 Ea (1 ea)	180-Large Fab	
D3066-1	Spacer	6 Ea (2 ea)	180-Large Fab	
MS20600-AD4W4	Rivet	48 Ea (16 ea)	180-Large Fab	
AN3-35A	Bolt	6 Ea (2 ea)	250-Packaging	
AN4-13A	Bolt	24 Ea (8 ea)	250-Packaging	
AN5-36A	Bolt	6 Ea (2 ea)	250-Packaging	
D2230-3	Mounting Lug	12 Ea (4 ea)	250-Packaging	
D2618	Bushing	6 Ea (2 ea)	250-Packaging	
D2856-400-720	Abrasion Strip 4" X 7.20"	6 Ea (2 ea)	250-Packaging	
D3235-1	Mounting Lug	6 Ea (2 ea)	250-Packaging	
D3278-041	Support Assembly	3 Ea (1 ea)	250-Packaging	
MS21042L3	Nut	6 Ea (2 ea)	250-Packaging	
MS21042L4	Nut	24 Ea (8 ea)	250-Packaging	
MS21042L5	Nut	6 Ea (2 ea)	250-Packaging	
NAS1149D0363J	Washer	12 Ea (4 ea)	250-Packaging	
NAS1149D0463J	Washer	48 Ea (16 ea)	250-Packaging	
NAS1149D0563J	Washer	12 Ea (4 ea)	250-Packaging	
DSI 9410-011	Amends Installation Of D350-591-311/-312 Steps	3 Ea (1 ea)	250-Packaging	

Job Allocations

Operation	Component Part	Required	Inventory	Allocated
90-Start up Operation	D3067-1	6	23	0
	D3219-1	6	44	0
	D3272-1	3	0	0
180-Large Fab	D3065-041	3	12	0
	D3066-1	6	50	0
	MS20600-AD4W4	48	2,001	0
250-Packaging	AN3-35A	6	162	0
	AN4-13A	24	563	0
	AN5-36A	6	188	0
	D2230-3	12	129	0
	D2618	6	276	0
	D2856-400-720	6	129	0
	D3235-1	6	54	0
	D3278-041	3	20	0
	DSI 9410-011	3	7	0
	MS21042L3	6	3,495	0
	MS21042L4	24	1,222	0
	MS21042L5	6	961	0
	NAS1149D0363J	12	3,533	0
	NAS1149D0463J	48	2,743	0
	NAS1149D0563J	12	1,454	0

Part Specifications

Specifications could not be found.

DQA: _____ Date: _____

WORK ORDER NON-CONFORMANCE / UPDATE



QA Closed: _____ Date: _____

Work Order update only ☐

Work Order: _____ Part No. _____ NCR No. _____	DISPOSITION Rework ☐ Scrap ☐ Use-as-is ☐ Suspected Unapproved ☐	AGAINST DEPARTMENT/PROCESS <table style="width:100%; border: none;"> <tr> <td style="border: none;">Skid-tube ☐</td> <td style="border: none;">Cross tube ☐</td> <td style="border: none;">Water Jet ☐</td> <td style="border: none;">Engineering ☐</td> </tr> <tr> <td style="border: none;">Machining ☐</td> <td style="border: none;">Small Fab ☐</td> <td style="border: none;">Prod. Eng. Coord. ☐</td> <td style="border: none;">Quality ☐</td> </tr> <tr> <td style="border: none;">Thermoforming ☐</td> <td style="border: none;">Finishing ☐</td> <td style="border: none;">Rec/Store/Packaging ☐</td> <td style="border: none;">Other ☐</td> </tr> <tr> <td style="border: none;">Large Fab ☐</td> <td style="border: none;">Composite ☐</td> <td style="border: none;">Supplier ☐</td> <td></td> </tr> </table>				Skid-tube ☐	Cross tube ☐	Water Jet ☐	Engineering ☐	Machining ☐	Small Fab ☐	Prod. Eng. Coord. ☐	Quality ☐	Thermoforming ☐	Finishing ☐	Rec/Store/Packaging ☐	Other ☐	Large Fab ☐	Composite ☐	Supplier ☐	
Skid-tube ☐	Cross tube ☐	Water Jet ☐	Engineering ☐																		
Machining ☐	Small Fab ☐	Prod. Eng. Coord. ☐	Quality ☐																		
Thermoforming ☐	Finishing ☐	Rec/Store/Packaging ☐	Other ☐																		
Large Fab ☐	Composite ☐	Supplier ☐																			
Date : _____	Step #: _____	QTY Effective : _____		MRB (QSI042) Approval																	
Description Work Order Deviation		Disposition		Completed By																	
				Lead hand / Supervisor Approval Verification																	
				QC / QA Coordinator Approval																	

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Container No: S051664

Part: D350-591-311

Job No: 172736

Serial No/Batch: S051664

Revision: _____

Inspector: _____

Date: 03/15/18

ULT CATEGORY

Unqualified	☐ Power Loss/Surge ☐ Folio/Program ☐ Grain ☐ Weld ☐ Wrong Stock Pulled ☐ Out of Sequence ☐ Off-set ☐ Mislabeled ☐ Fit/Function ☐ Misaligned/off center	☐ Positioned Wrong ☐ Outside Dimensions ☐ Over/Under tolerance ☐ Part Incorrect ☐ Part Lost/Missing ☐ Part Moved ☐ Drawing ☐ Finish ☐ Misread ☐ Turning Sequence	
/Unclear			



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Container View (Active) - Master Unit Containers

Master Unit No	Container No	Part No	Part Name	From Container	Current Location	Quantity
002476	S060545	AN3-35A	Bolt	S017089 ✓	Packaging1-3	6
002476	S060544	AN4-13A	Bolt	S045860 ✓	Packaging1-3	24
002476	S060543	AN5-36A	Bolt	S041116 ✓	Packaging1-3	6
002476	F164011 ✓	D2230-3	Mounting Lug		Packaging1-3	1
002476	S060555	D2230-3	Mounting Lug ✓	s051382 ✓	Packaging1-3	11
002476	S060546	D2618	Bushing ✓	S043411 ✓	Packaging1-3	6
002476	S060547	D2856-400-720	Abrasion Strip 4" X 7.20"	S051490 ✓	Packaging1-3	6
002476	S060542	D3235-1	Mounting Lug ✓	s049171	Packaging1-3	6
002476	S053036 ✓	D3278-041	Support Assembly	S053034	Packaging1-3	1
002476	S060537	D3278-041	Support Assembly	s059873 ✓	Packaging1-3	2
002476	S060536	MS21042L3	Nut	S038764 ✓	Packaging1-3	6
002476	S060535	MS21042L4	Nut	S045901	Packaging1-3	24
002476	S060533	MS21042L5	Nut	S041167 ✓	Packaging1-3	6
002476	S060532	NAS1149D0363J	Washer	S015269 ✓	Packaging1-3	12
002476	S060531	NAS1149D0463J	Washer	S045845 ✓	Packaging1-3	48
002476	S060530	NAS1149D0563J	Washer	S039036 ✓	Packaging1-3	12

Note: Ad hoc query view of Part.dbo.Container where Container.Active = 1.

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Qty -213	Qty -214	Qty -215	Qty -216	Qty -311	Qty -312	Part Number	Description
X						D350-591-213	<i>Heli-Access-Step™</i> , Short Step – High Skid, LH
	X					D350-591-214	<i>Heli-Access-Step™</i> , Short Step – High Skid, RH
		X				D350-591-215	<i>Heli-Access-Step™</i> , Short Step – Low Skid, LH
			X			D350-591-216	<i>Heli-Access-Step™</i> , Short Step – Low Skid, RH
				X		D350-591-311	<i>Heli-Access-Step™</i> , Long Step – High Skid, LH
					X	D350-591-312	<i>Heli-Access-Step™</i> , Long Step – High Skid, RH
1						D3078-041	STEP ASSEMBLY (HIGH-SHORT, LH)
	1					D3078-042	STEP ASSEMBLY (HIGH-SHORT, RH)
		1				D3168-041	STEP ASSEMBLY (LOW-SHORT, LH)
			1			D3168-042	STEP ASSEMBLY (LOW-SHORT, RH)
				1		D3272-041	STEP ASSEMBLY (HIGH-LONG, LH)
					1	D3272-042	STEP ASSEMBLY (HIGH-LONG, RH)
2	2	2	2	4	4	D2230-3	MOUNTING LUG
2	2	2	2	2	2	D2618	BUSHING
4	4	4	4			D2732-030	CUSHION
				2	2	D2856-400-720	ABRASION STRIP
2	2	2	2	2	2	D3235-1	MOUNTING LUG
				1	1	D3278-041	SUPPORT ASSEMBLY
2	2	2	2	2	2	AN3-35A	BOLT
				8	8	AN4-13A	BOLT
4	4	4	4			AN4-15A	BOLT
2	2	2	2	2	2	AN5-36A	BOLT
4	4	4	4	4	4	NAS1149D0363J	WASHER (AN960JD10)
12	12	12	12	16	16	NAS1149D0463J	WASHER (AN960JD416)
4	4	4	4	4	4	NAS1149D0563J	WASHER (AN960JD516)
2	2	2	2	2	2	MS21042L3	NUT
6	6	6	6	8	8	MS21042L4	NUT
2	2	2	2	2	2	MS21042L5	NUT
				1	1	*DSI 9410-011	STEP MODIFICATION KIT

*DSI 9410-011 Step Modification Kits are provided with all D350-591-311 and D350-591-312 Steps. This kit is provided as an option for the installer and is therefore **NOT REQUIRED** to complete the installation of the D350-591-311 or D350-591-312 Steps. Refer to Figure 15 for installation of the DSI 9410-011 Kit.